

Date: Tuesday, 19/05/2009 10:17:20 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : GUARD
 Job Number : 47984
 Estimate Number : 13937
 P.O. Number :
 This Issue : 19/05/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D39271
 First Issue : // Type : MACHINED PARTS Drawing Number : D3927 PREL
 Drawing Revision : PREL
 Material :
 Due Date : 26/05/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : MF 09-05-19
 Comment : Est Rev:A New Issue 09-05-15 JLM Verified By:EC



Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 MDELINB1000X4000 5000 Pul Black Delrin Bar 1" x 4"



Comment: Qty.: 1.3650 f(s)/Unit Total: 1.3650 f(s)

Black Delrin Bar 1" x 4" 5" Pul 09-05-26

BATCH: ~~111808~~

111808

HB 9-5-26

(2)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

CUT BLANK AS PER FILE D3927-1 BLANK

HB 9-5-26

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA821 Rev: AA & Dwg D3927 Rev: PREL

2-Deburr per dwg D3927

DTP 09/05/29

(2)

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DTP 09/05/29

(2)

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ENGINEERING
APPROVAL

P 09.06.01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/05/2009 10:17:20 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUARD

Job Number: 47984

Part Number: D39271

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ENG LAB /
HAI ONLY

09.08.27

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



POSITIVE RECALL

EFFECTIVE 09.05.19 AUTH LL

RELEASED _____ DATE _____

NOT RECD - TO BE
USED FOR HAI ONLY
(PART SCRATCHED)
09/08/27

Dart Aerospace Ltd

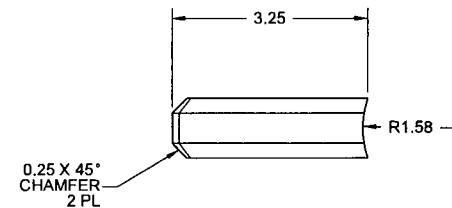
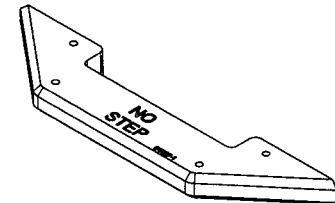
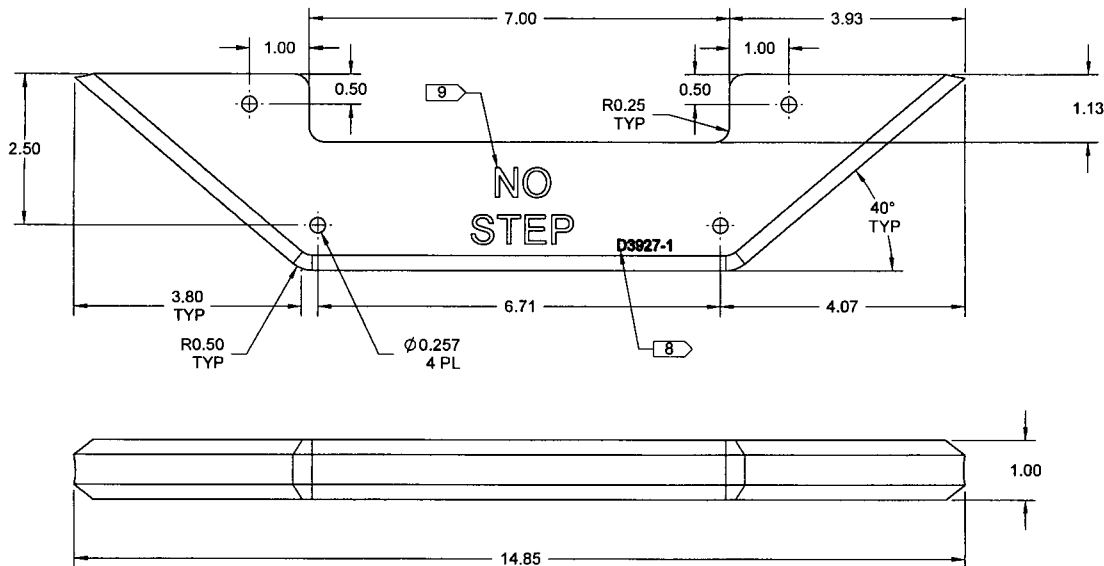
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PRELIMINARY ISSUE

D3927-1 GUARD

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL 1.0 THICK
PER DART SPEC M-DELRIN-S1.0
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.90 lbs
- 8) ENGRAVE "D3927-1" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015 ± 0.005 AT LOCATION INDICATED
- 9) ENGRAVE "NO STEP" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015 ± 0.005 AT LOCATION INDICATED

A	NEW ISSUE	BY	09.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.31		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. **D3927**

TITLE **GUARD**

REV. A
SHEET 1 OF 2

SCALE: NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

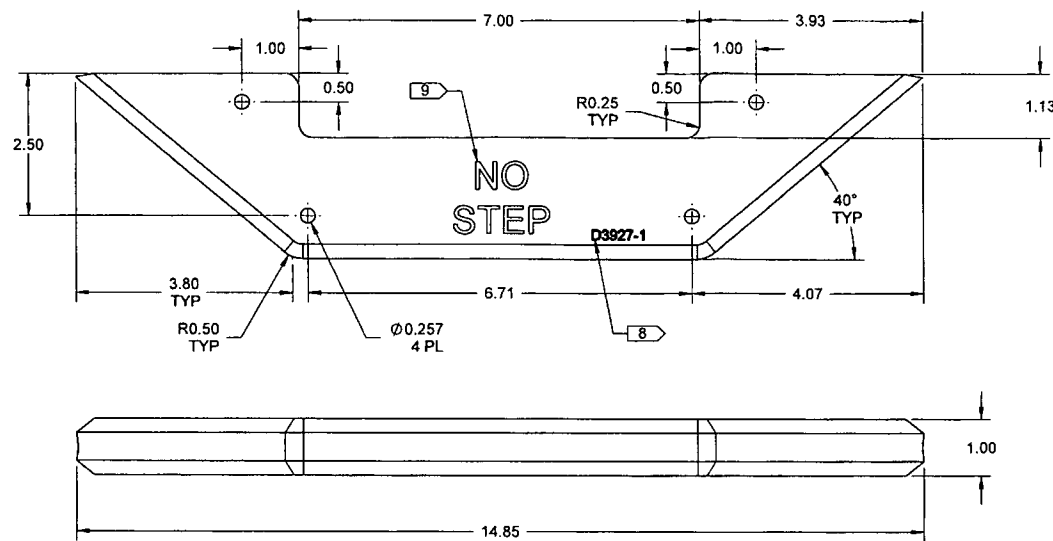
8 7 6 5 4 3 2 1

D

C

B

A



D3927-1 GUARD

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL 1.0 THICK
PER DART SPEC M-DELRIN-S1.0
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.90 lbs
- 8) ENGRAVE "D3927-1" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015 ± 0.005 AT LOCATION INDICATED
- 9) ENGRAVE "NO STEP" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015 ± 0.005 AT LOCATION INDICATED

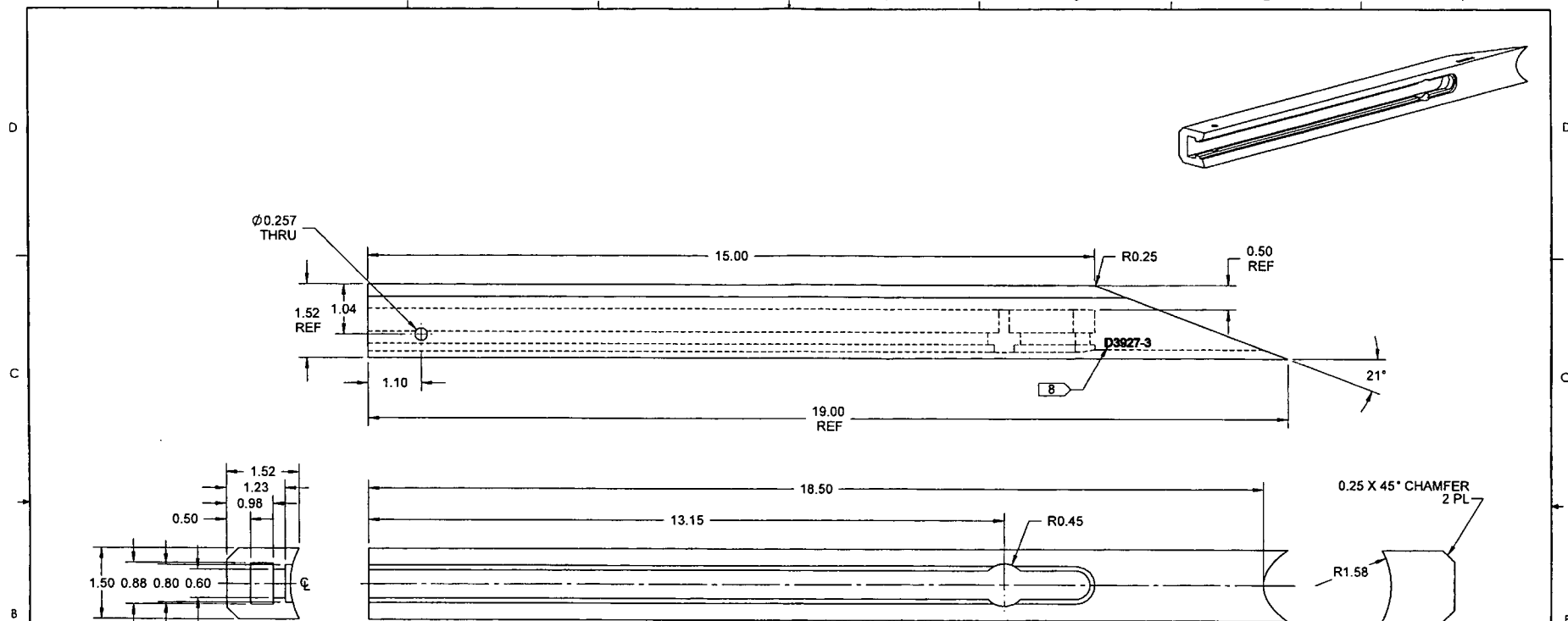
47984

RELEASED
09/02/17

A		NEW ISSUE		BY		09.03.31	
REV.		DESCRIPTION		BY		DATE	
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MFG. APPR.				DRAWING NO.		REV. A	
APPROVED				D3927		SHEET 1 OF 2	
DE APPR.				TITLE		SCALE	
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8 7 6 5 4 3 2 1

8 7 6 5 4 3 2 1



D3927-3 GUARD

47984

RELEASED
01/18/17

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL 1.5 THICK
PER DART SPEC M-DELRIN-S1.5
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.82 lbs
- 8) ENGRAVE "D3927-3" TO DEPTH OF 0.005 WITH TOOL TIP RAD OF 0.015 ± 0.005 IN LOCATION INDICATED

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8 7 6 5 4 3 2 1